	in control of the con								6	
Work Order ID Wednesday, February 27,			*978	809*		Ĵ	4		9	Page 1
Item ID: D3238-5 Revision ID: Item Name: Plate	5	A	ccept	*N90	กก4ก	100	* S	etup Star Stoj	ı V.	S1*
Start Date: 2/27/201 Required Date: 2/27/201 Reference:		*10* *10*		Cust Iter Custome						
Approvals: Process QC:	s Plan: WF	Date: 3-2-27 Date:	Tooling: SPC (Y/N):		Date:		R	un Star Stop	1/1	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3238	Revision Nbr Rev C									
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo Run "Blank l	File" in D3238 Note:1 blank	0.00 0.00 makes 18 prts	N						
110 *110* Mill Conv Conventional Milling Machine	CONVENTIONAL MILL Memo Mill Serratio	ING MACHINE n as per Dwg D3238 Using I	0.00 0.00 DT8934	A	13-	2	Z /			
120 * 12 0* oc	QC2- Inspect parts off ma	ochine FAI/FAIB	0.00							
Quality Control	Memo		0.00							

Work Order ID 97809 Page 2 Wednesday, February 27, 2013 9:07:06 AM Item ID: D3238-5 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Plate *10* **Start Date:** 2/27/2013 **Start Qty: 10.00 Cust Item ID:** Required Date: 2/27/2013 Req'd Qty: 10.00 *10* **Customer:** Reference: Start Run **Approvals:** Process Plan: Date: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Tool ID Plan Set Up/ Accept Reject Reject Insp. Work Center ID **Description** Run Hours Code **Qty Oty** Stamp Number 130 0.00 FLOW WATER JET *120* 12 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3238 Dwg Rev: Prog Rev: 2-Deburr if necessary reations are correct direction! 140 QC2- Inspect parts off machine FAI/FAIB 0.00 *140* QC 0.00 Memo Quality Control to be done by Enc Downing 150 QC8- Inspect parts - second check *150* OC Memo

Quality Control

Work Order ID 97809 Wednesday, February 27, 2013 9:07:06 AM				*97809*						Pa	age 3
Item ID: Revision ID: Item Name:	D3238-5			Accept	*N900	0401	NN*	Setup	Start Stop	*NS1	
Start Date: Required Date Reference:	2/27/2013 :: 2/27/2013	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item II Customer:	D:				IN.7/	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	•	ite:		Run	Start Stop	*NR1	*
Sequence ID/ Work Center I 160 *160* HandFinish Hand Finishing	ID	Operation Description Chemical Conversion Co	at per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID		an Accode Qty	Qt	ty	Reject Insp. Number Stan	np
170 *170* QC Quality Control	i e.	QC3- Inspect Part Finish Memo		0.00 AS 16 0.00 9.3	13/2/27		(1	(12)			

0.00

Memo

180

180 Packaging

Packaging

13-2-27

Work Ord Wednesday, Fe		7809 13 9:07:06 AM		*978	309*	_					Page 4
Item ID: Revision ID: Item Name:	D3238-5 Plate			Accept	*N900	040	100)* s	•		IS1* IS2*
Start Date: Required Date Reference:	2/27/2013 e: 2/27/2013	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:				-	
Approvals:	Process Pl QC:	an:	Date:	Tooling: SPC (Y/N):		ate: ate:		F		top *N	JR1* JR2*
Sequence ID/ Work Center	ID	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe	Insp. r Stamp
190 QC Quality Control		Memo		0.00				Ļ	レゴ	13-0	v-18

MF 13-2-28 Wednesday, February 27, 2013 9:07:05 A

Work Order ID:

97809

Parent Item:

D3238-5

Parent Item Name:

Plate

Start Date: 2/27/2013

Required Date: 2/27/2013

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 06-10-20 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	406.8900	0.012	0.1263158		Im 13-2-22
•												

Location	Loc Qty	Loc Code	
MAT022	406.89		
105411	12		
109424	8		
113796	10		
114025	3.4		
117392	38.2		
118180	54		
119117	41.15		119117
120989	79.34		
123217	160.8		

DART AEROSPACE LTD	Work Order:	47.809
Description: Plate	Part Number:	D3238-5
Inspection Dwg: D3238 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

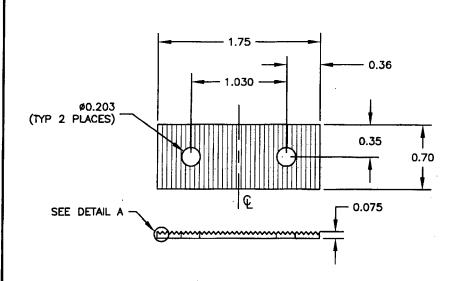
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	+/-0.030	1,744"	_		V	Jamos
0.70	+/-0.030	0.6984	-		V	
0.35	+/-0.030	0.352	-		V	
0.36	+/-0.030	0.358"	_		V	
1.030	+/-0.010	1.038,	-		V	
Ø0.203	+0.005/-0.001	0.206	_		ν	
			·			

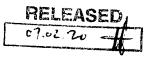
Measured by:	Jm	Audited by:	DAS)		Prototype Approval:	N/A
Date:	13-2-27	Date:	16/D/2/Z	7	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM , ,	
В	07.02.23	Dwg Rev. updated	KJ/JLM	B



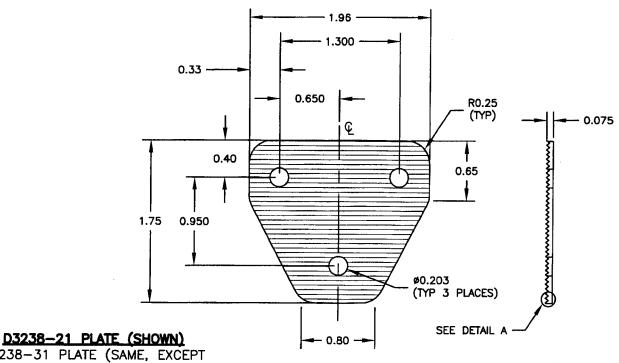
DESIGN #	DRAWN BY		ROSPACE LTD RY, ONTARIO, CANADA
CHECKED	APPROVED //	DRAWING NO.	REV. C
LE	-#	D3238	SHEET 2 OF 3
DATE		TITLE	SCALE
07.02.19		PLATE	1:1





D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

±97809



D3238-31 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

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